

Work Order ID 133438

133438

Page 1

Monday, June 08, 2015 4:09:41 PM

Item ID: D2370-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Litter Frame Assembly
Start Date: 6/08/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/08/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: JUN 09 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2370	REV D

100 PURCHASING 0.00
100
Purchasing Memo 0.00
Purchasing Issue p/o: 28803
Order: Model 12-2A undrilled with grey pad & black belts
Supplier: Ferno Aviation
Letter of compliance required

CZ JUN 12 2015 1

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
Packaging Memo 0.00
Packaging Insure that letter of compliance is attached to w/o

IX SP15-06-22

120 QC6- Inspect dimensions to drawing 0.00
120
QC Memo 0.00
Quality Control

Q 15-06-22

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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133438

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Item ID: D2370-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Litter Frame Assembly
 Start Date: 6/08/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/08/15 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00			DAS 30 9-89	1			JUN 22 2015
130									
Small Fab	Memo	0.00							
Small Fab	1- Assemble D2374 STUDS WITH HARDWARE as per Dwg D2370 2-Assemble d2379 belt as per dwg								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							DAS 9 9-89
Quality Control	Check for loose rivet and ensure fit of D4812-041								
150	Identify as per dwg & Stock Location: <u>PPP</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging	LOCATION : GA								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Item ID: D2370-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Litter Frame Assembly
Start Date: 6/08/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/08/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ

JUN 22 2015

mf

5-6-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Picklist Print

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Work Order ID: 133438

133438

Parent Item: D2370-1

D2370-1

Parent Item Name: Litter Frame Assembly

Start Date: 6/08/15

Required Date: 6/08/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2370-1P		Purchased	No				Each	0.0000		1			
D2370-1P									**				
Litter Frame Assembly													
D2374		Manufactured	No				Each	22.0000		4			
D2374									**				
Stud													
				<u>Location</u>				<u>Loc Qty</u>					
				ST006				22					
				130945				10					
				131804				12					
D2378		Manufactured	No				Each	38.0000		4			
D2378									**				
Bolt													
				<u>Location</u>				<u>Loc Qty</u>					
				ST006				38					
				131082				25					
				131924				13					
D2484		Manufactured	No				Each	30.0000		4			
D2484									**				
Locknut													
				<u>Location</u>				<u>Loc Qty</u>					
				ST007				30					
				130922				30					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Picklist Print

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133438

Parent Item: D2370-1

D2370-1

Parent Item Name: Litter Frame Assembly

Start Date: 6/08/15

Required Date: 6/08/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0416J

Purchased

No

Each

4,800.000

4

DAS
30
~~9.89~~

JUN 22 2015

NAS1149D0416.J

WASHER

Location

Loc Qty

Loc Code

ST270

4800

m131511

4800

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

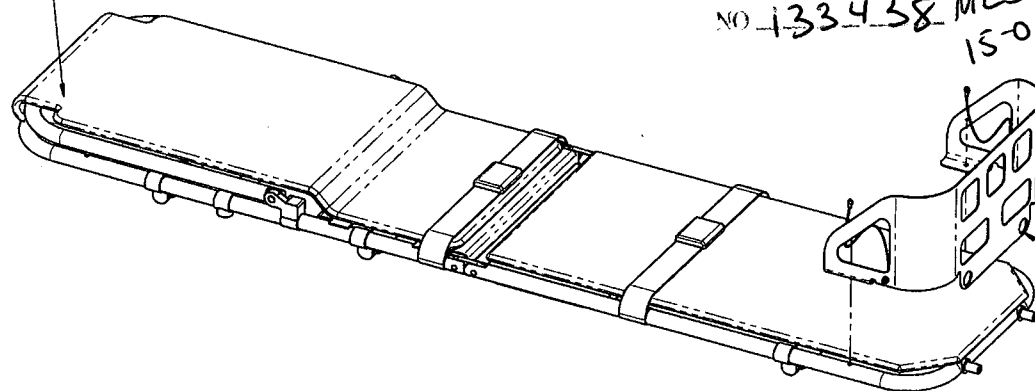
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OTHER : ☐					

ITEM	QTY	P/N	DESCRIPTION
	X	D2370-041	LITTER ASSEMBLY
1	1	D2370-1	LITTER FRAME ASSY
2	1	D4812-041	PATIENT STOP ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 133438 *MLJ*
15-06-09

D2370-1 LITTER FRAME ASSEMBLY



D4812-041 PATIENT STOP ASSY

POSITION PATIENT STOP OVER
FWD STUDS AND SECURE
WITH PIP PINS

D2370-041 LITTER ASSEMBLY

RELEASED
2013-05-16
MD

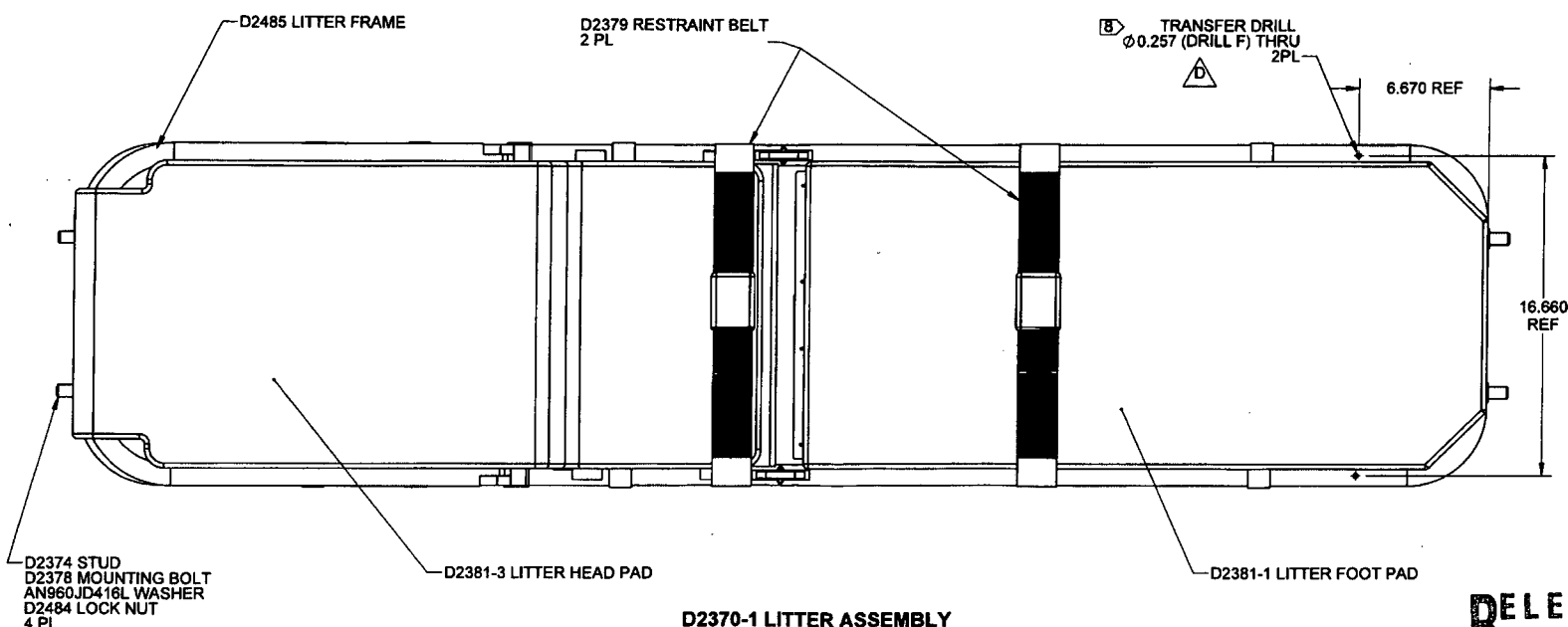
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 25.73 Lbs

D	Ø0.257 HOLES WERE Ø0.191 HOLES, 2PL (ZN C3-2) CREATED - 1 AND -041 ASSEMBLIES, NEW DWG FORMAT	DB	13.03.27
C	ADD ALTERNATE FOR D2484, MS SCREWS, TAPPED HOLES AND 5.00 WAS 5.34	KE	06.11.21
B	ADDED Ø0.191 HOLES	KE	98.08.09
A	NEW ISSUE	NA	95.02.20
REV.	DESCRIPTION	BY	DATE

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	<i>AP</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AP</i>	D2370	SHEET 1 OF 2
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>AP</i>	LITTER ASSEMBLY	NTS
DATE	13.03.27	COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
	X	D2370-1	LITTER ASSEMBLY
1	4	D2374	STUD
2	4	D2378	MOUNTING BOLT
3	2	D2379	RESTRAINT BELT
4	1	D2381-1	LITTER FOOT PAD
5	1	D2381-3	LITTER HEAD PAD
6	4	D2484	LOCK NUT
7	1	D2485	LITTER FRAME
8	4	AN960JD416L	WASHER



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2370-1" USING A REMOVABLE TAG AS PER QS1 044 METHOD 6.6
 - 7) WEIGHT: 24.69 Lbs
 - 8) TRANSFER DRILL USING D4812-041 AS TEMPLATE. ENSURE FIT AND REMOVE FOR SHIPPING

RELEASED
2013-05-16

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>2/</i>	D2370	SHEET 2 OF 2
APPROVED	<i>1/</i>	TITLE	SCALE
DE APPR.	<i>1/</i>	LITTER ASSEMBLY	NTS
DATE	13.03.27	COPYRIGHT © 1986 BY DART AEROSPACE LTD.	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28803**

Purchase Order Date 6/12/2015

PO Print Date 6/12/2015

Page Number 1 of 2

Order From :

VU-FER001

FERNO AVIATION INC.
735-B BRANCH DR.
ALPHARETTA, GA 30004
US

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Contact Name

Vendor Phone 770 521 1005

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D2370-1P	Litter Frame Assembly	6/26/2015		1.00 ✓ Each	\$1,706.00	\$1,706.00
			Yes				
			6/26/2015				

AS PER DGW D2370 REV. D
B133439

Line Total: \$1,706.00

2	D2370-1P	Litter Frame Assembly	6/26/2015		1.00 ✓ Each	\$1,706.00	\$1,706.00
			Yes				
			6/26/2015				

AS PER DGW D2370 REV. D
B133438

Line Total: \$1,706.00

PO Instructions: Fedex Acc#151793240

Note:

6/12/2015

FERNO Aviation, INC.

Commercial Invoice

735-B Branch Drive
Alpharetta, GA 30004
Office 770.521.1005 Fax 770.521.0910
<http://aviation.ferno.com>

DATE	INVOICE NO.
6/16/2015	15688

BILL TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Attn: Accounts Payable

SHIP TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Ref: PO28803

PO NO.	TERMS	REP	SHIP DATE	SHIP VIA	FOB
PO28803	Net 30	CW	6/16/2015	fedEx Int'l Pri	Alpharetta,GA
ITEM	DESCRIPTION		QTY	UNIT PRICE	AMOUNT
12-2A (DART)	12-2A Litter Assembly W/Gray FAA Approved cover/pad assy. and Black FAA approved patient restraints, Serial # 15N329711, 15N329712 (HS Code 8803.30.00.00) Order will ship via Fed-X using Fed-X Acct. #151793240.		2	1,706.00	3,412.00
Thank you for your order!				Total	\$3,412.00